

Date: Thursday, 5/11/2006 10:42:05 AM  
 User: Kim Johnson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
 Job Number : 27075  
 Estimate Number : 10614  
 P.O. Number : N/A Part Number : D265621  
 This Issue : 5/11/2006 S.O. No. : N/A Drawing Number : D2656 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D  
 Previous Run : N/A Material : N/A  
 Written By : SKB Comment: Rekey Due Date : 5/30/2006 Qty: 50 Um: Each  
 Checked & Approved By : OK 06.05.10  
 Comment : Est: D 02.10.25 Re-format KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG

PURCHASING



## Comment: PURCHASING

Issue P/O: 1230

Email or ship DXF file to vendor

Laser Cut per Dwg D2656 flat pattern D2656-21

Material release note required

C20410511

(50)

2.0

D265621F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)  
 Wearplate

3.0

PACKAGING 1

PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

R4/5/25

(60)

4.0

QC6

DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-21T1

R4/5/29

(60)

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary.

N/A 06006/01  
SAP 06006/02

(60)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/11/2006 10:42:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27075

Part Number: D265621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-21

5A006:06:02 60  
5AD 06:06:03 60  
SA

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.06.05 (60)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/06/21

(60)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 0606 22

(60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 7021

FC 0606 22

(60)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/22 (60)

Job Completion



W 06/06/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

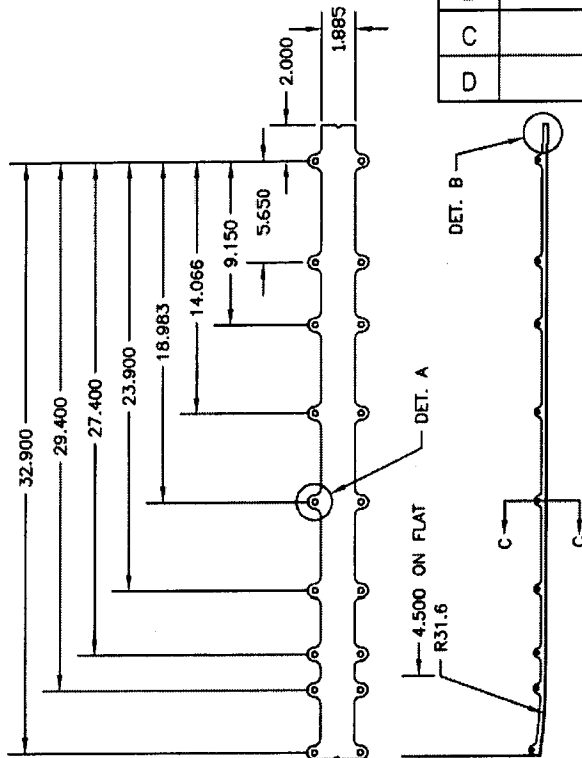
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

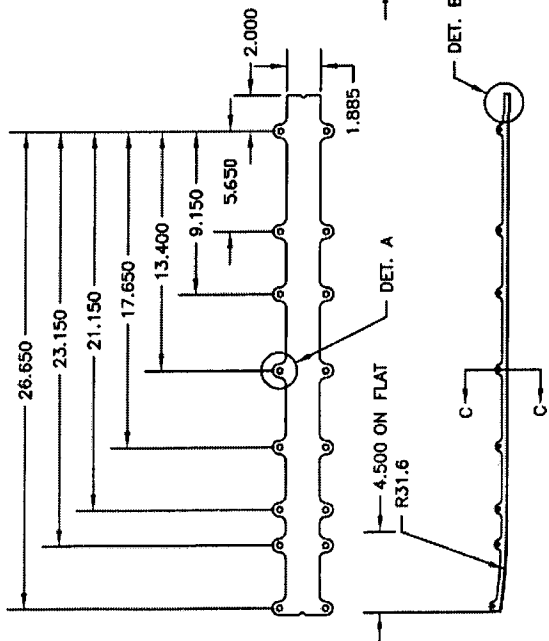


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DS		CP		PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. D
				D2656	SHEET 1 OF 4
DATE			TITLE		SCALE
05.08.17			WEARSHOE		1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

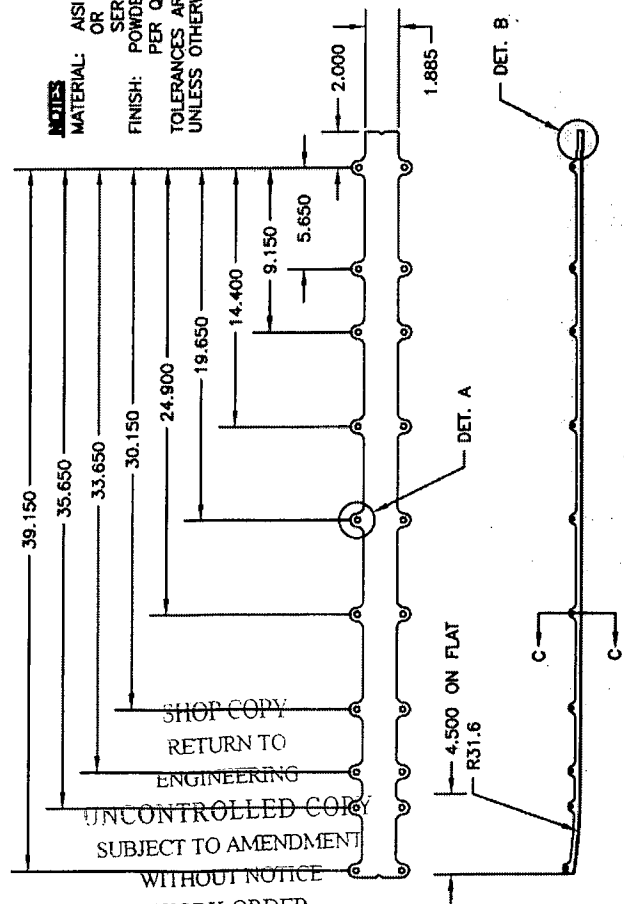
D2656-13



D2656-11



D2656-15



NOTES  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA C40-21, 38W/44W/50W/60W/70W  
SERIES STEEL 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANITEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

RELEASED  
05.09.08

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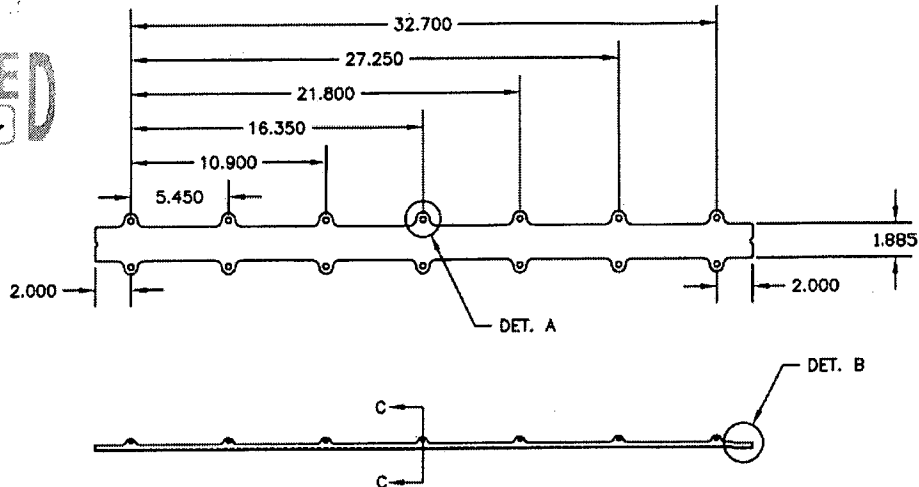
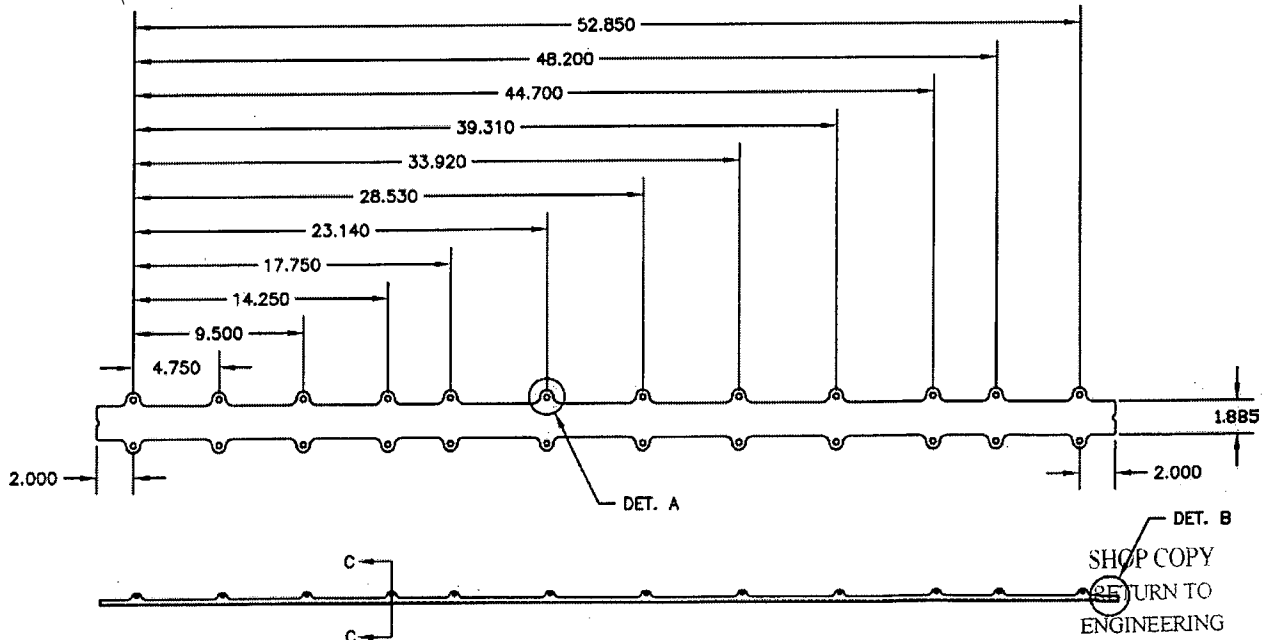
WORK ORDER  
NO. 27076

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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>

**RELEASED**  
*DS 07.06***D2656-21****D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

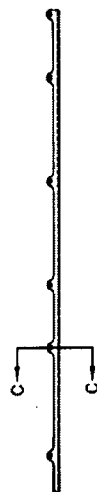
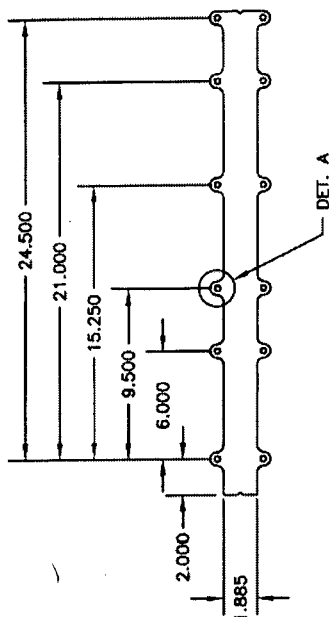
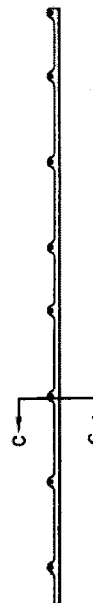
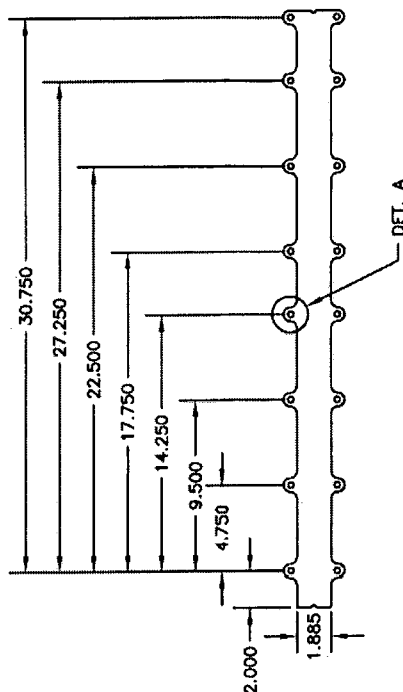
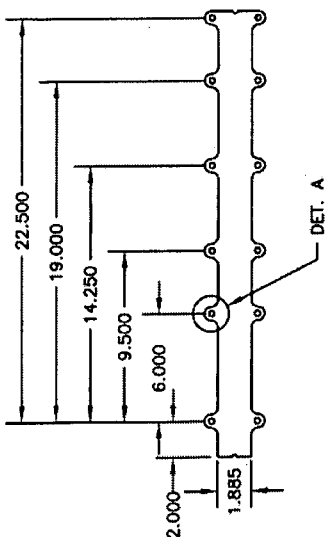
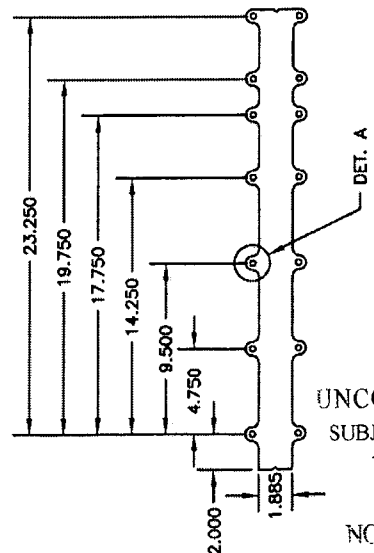
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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>

**D2656-33****D2656-37****RELEASED**  
05.09.16 *[Signature]***D2656-31****D2656-35**

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NOTES: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

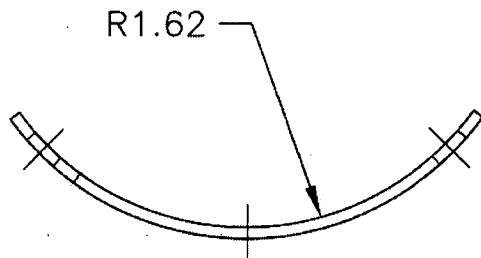
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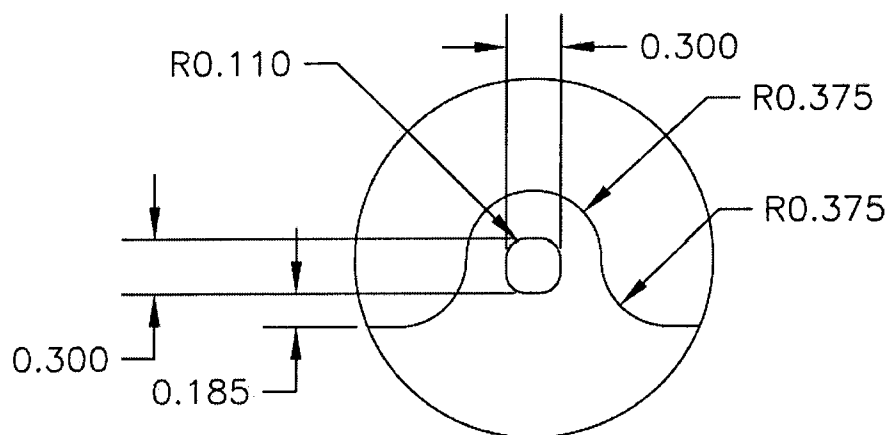
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

### SECTION C-C

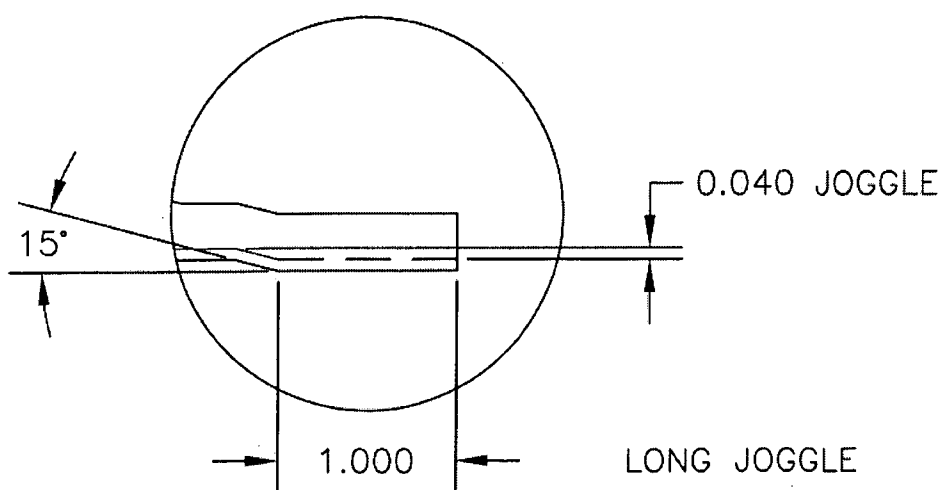


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### DETAIL A



### DETAIL B



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P.O. # 1230  
20GA CRS.

New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal Private Bag 12225, Auckland, New Zealand  
Telephone: (09) 572 8000 / 572 8001 / 572 8002  
Fax: (09) 571 8000

## TEST CERTIFICATE

THE 50372107

CUSTOMER			WILSON		P5050501002			SPECIFICATION			ASTMA108 C8 Type A			CERTIFICATE No			TC115030					
CUSTOMER D/N			R9-217-742						PRODUCT			CRA WIDE COIL			PAGE			1 of 1				
ROLL D/N			48068						DIMENSIONS			0.833" x 48" = Coil			DATE			02 August 2005				
PACK NUMBER	HEAT No.	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A108)						
		C	SE	Mn	P	S	CU	NI	CR	MO	V	Nb	TI	AL	Si	CS	BEND 180°	YIELD	TS	WELONG OLA	HARDNESS HRB	LENGTH (feet)
R9-464017-00	844863	6	TR	28	7	17	15	23	14	3	1	3	3				Good				45	2418
R9-464018-00	844863	6	TR	28	7	17	15	23	14	3	1	3	3				Good				45	2464
R9-464019-00	779675	6	TR	28	14	36	11	21	23	2	1	1	3				Good				48	2638
R9-464020-00	779675	6	TR	28	14	16	11	11	33	2	1	1	3				Good				45	2825
R9-464021-00	779675	6	TR	28	17	33	17	22	17	2	1	1	3				Good				50	1923
R9-464022-00	779675	6	TR	23	17	13	32	17	2	3	1	3	3				Good				50	1978

YIELD	GAUGE LENGTH (ALL)	PLASTIC STRAIN RATIO (%)	IMPACT TEST	(C) 5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A) 0.1% PROOF STRESS	(A) 200mm (C) 50mm	(A) 0 (C) 0.1	(A) 10mm x 10mm	(D) 2.5mm x 10mm	(A) C+MnS
(B) LOWER YIELD STRESS	(B) 50mm (D) 50mm	(B) 0.5 (D) 0.5	(B) 2.5mm x 10mm	(E) 5mm x 10mm	(B) C+MnS+(C+MnS)/15
					(C) C+MnS+5/24

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

CONMETALLURGIST

